

shp ASH

Work Order ID 63451



Page 1

Tuesday, November 02, 2010 9:22:09 AM

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 11/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-02

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4148 | C |

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

⇒ m-l 10/11/09

(2X)

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Solulor

Pho →

120

0.00



Packaging

Identify as per dwg & Stock Location: *468*

Memo

0.00

Packaging

21/1/9 sf (20)

Dart Aerospace Ltd

| W/O: 63451 | | WORK ORDER CHANGES | | | | | |
|-----------------|-------------|--------------------------------------|----|------|-----|-------------------------------------|-----------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | <i>Perm. change</i> | | | | | |
| <i>10/10/09</i> | <i>#110</i> | <i>change to QCC inspection test</i> | | | | | <i>S</i> <i>10/10/09</i> |
| | | | | | | | |

Part No: D4148-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 11/2/2010 Start Qty: 2.00



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Required Date: 11/9/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/09 [Signature]

MF
10-11-9

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 02, 2010 9:22:14 AM

Page 1

Work Order ID: 63451

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd




Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
10.10.29 as per revC DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2690-6  Lanyard Assembly | | Manufactured | No | | | 100 | Each | 23.0000 | 1 | 2 | | | |
| <div> <div>Location</div> <div>ST020</div> <div>59960</div> <div>61382</div> </div> <div> <div>Loc Qty</div> <div>23</div> <div>1 ✓</div> <div>22 ✓</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| D3910-1  Crosstube Lug | | Manufactured | No | | | 100 | Each | 9.0000 | 1 | 2 | | | |
| <div> <div>Location</div> <div>st507</div> <div>59349</div> <div>59708</div> <div>62009 ✓</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>2</div> <div>1</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| D4091-1  Mounting Lug | | Manufactured | No | | | 100 | Each | 15.0000 | 1 | 2 | | | |
| <div> <div>Location</div> <div>ST460</div> <div>61008</div> <div>61993 ✓</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>1</div> <div>14</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |

m-d 10/11/09

m-d 10/11/09

m-d 10/11/09

2x

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Page 2

Work Order ID: 63451

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

D4148-1 *New Rev*
Crosstube Lug Plate, Fwd

Manufactured No

100 Each 8.0000 2 4

Location

Loc Qty

Loc Code

GA

8 B 63448

61006

2

62201

2

62830

4

(4)

SB 10/11/09

D4148-3 *New Rev*
Stud Receiver, Lower

Manufactured No

100 Each 7.0000 1 2

Location

Loc Qty

Loc Code

GA

7 B 63449

61007

6

62202

1

(2)

SB 10/11/09

D4148-5 *New Rev*
Eyebolt Stud

Manufactured No

100 Each 6.0000 1 2

Location

Loc Qty

Loc Code

GA

6

61005

6

2

SB 10/11/09

AN3C12A
Bolts

Purchased No

100 Each 73.0000 4 8

Location

Loc Qty

Loc Code

ST351

73

112314

8

114761

11

115392

4

116022 ✓

50

8x

m-l 10/11/09

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Shop Packet Print

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Page 3

Work Order ID: 63451

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, fwd

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

AN4C13A

Purchased

No

100

Each

61.0000

1

2



BOLT



m-l w/11/09

Location

Loc Qty

Loc Code

ST357

61

113359

3

114442 ✓

8

114615

50

2x

MS17984-C413

Purchased

No

100

Each

10.0000

1

2



PIN, QUICK RELEASE



m-l w/11/09

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

6

114523

1

114886 ✓

5

2x

MS20615-4M18

Purchased

No

100

Each

415.0000

8

16



Rivet



Ep 5/11/09

Location

Loc Qty

Loc Code

ST323

415

114808

152

115037

263

16

Tuesday, November 02, 2010 9:22:14 AM

Shop Packet Print

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Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 63451

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

100

Each

2,486.000

4

8



m-l w/11/09

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2410

112314 ✓

2410

8X

MS21043-4

Purchased

No

100

Each

946.0000

1

2



m-l w/11/09

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

906

112492

25

113069

8

114181

29

114523 ✓

244

114784

300

115936

300

2X

Dart Aerospace Ltd

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Tuesday, November 02, 2010 9:22:14 AM

Page 5

Work Order ID: 63451

Parent Item: D4148-041

Parent Item Name: Crosstube Lng Assembly, Fwd

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

100

Each

5,861.000

8

16



Washer



M. J. 10/11/09

Location

Loc Qty

Loc Code

ST297

5861

113524

10

113737

150

114341

26

115000

125

115698

78

115816

106

115832 ✓

3366

116025

2000

16x

NAS1149C0432R

Purchased

No

100

Each

658.0000

2

4



Washer



M. J. 10/11/09

Location

Loc Qty

Loc Code

ST297

658

114292

68

114742 ✓

590

4x

Tuesday, November 02, 2010 9:22:14 AM

Shop Packet Print

Page 5

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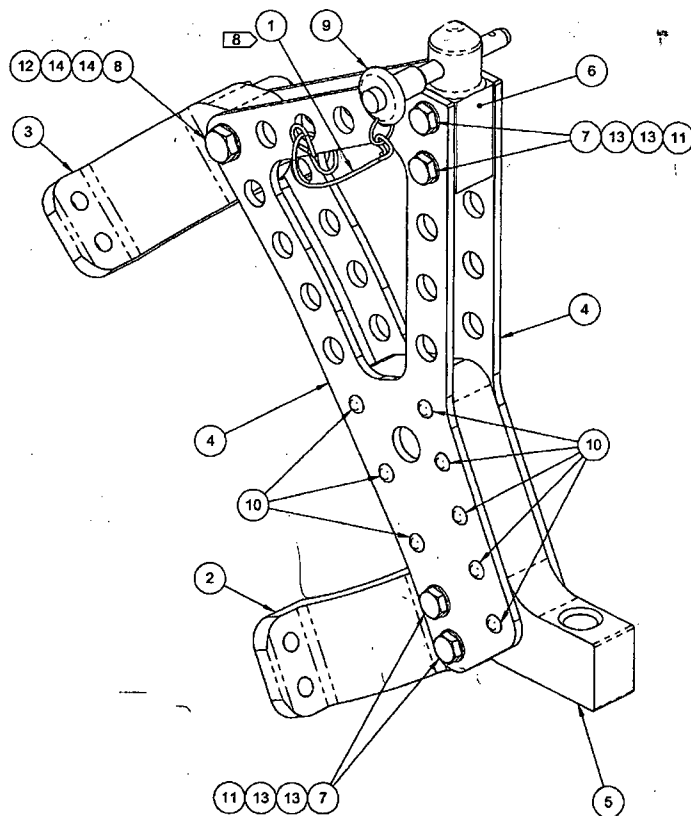
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
 7) WEIGHT: 3.63 lbs
 8) ATTACH D2690-8 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|----------------------|
| | X | D4148-041 | FWD X-TUBE LUG ASSY |
| 1 | 1 | D690-8 | LANYARD |
| 2 | 1 | D3910-1 | X-TUBE LUG |
| 3 | 1 | D4091-1 | MOUNTING LUG |
| 4 | 2 | D4148-1 | FWD X-TUBE LUG PLATE |
| 5 | 1 | D4148-3 | STUD RECEIVER LOWER |
| 6 | 1 | D4148-5 | EYEBOLT STUD |
| 7 | 4 | AN3C12A | BOLT |
| 8 | 1 | AN4C13A | BOLT |
| 9 | 1 | MS17984-C413 | PIP PIN |
| 10 | 8 | MS20615-4M18 | RIVET |
| 11 | 4 | MS21043-3 | NUT |
| 12 | 1 | MS21043-4 | NUT |
| 13 | 8 | NAS1149C0332R | WASHER |
| 14 | 2 | NAS1149C0432R | WASHER |

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 63451

2/10-11-02

RELEASED
 2010-10-28

| | | | |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|----------|
| C | REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-501 SHORT STEPS | MB | 10.10.12 |
| B | REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C8-5); REASON: SEE TR-D350-607.2 REV. B. | MB | 10.07.05 |
| A | NEW ISSUE | MB | 10.06.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.10.12 | | |

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. C
 SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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8 7 6 5 4 3 2 1

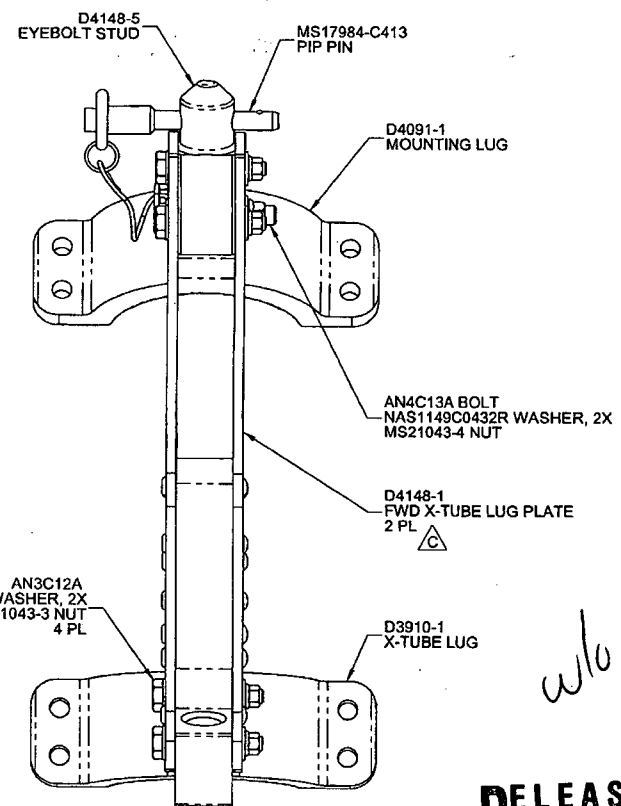
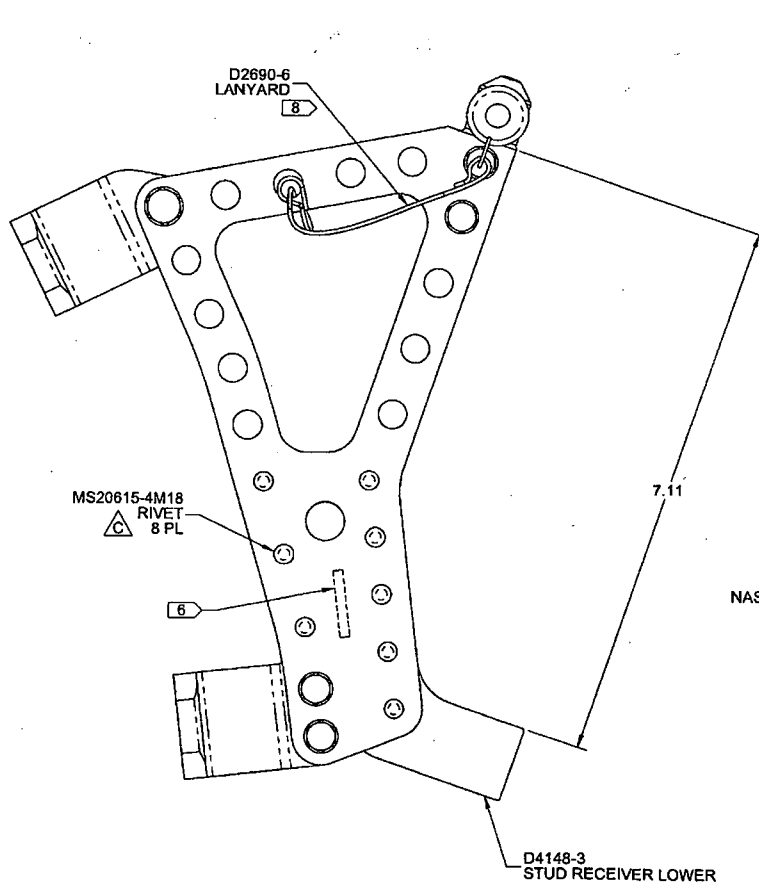
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NOTE: Date & initial all entries



w/o 63151

RELEASED
2010-10-28

D4148-041 FWD X-TUBE LUG ASSY

| | | | |
|------------|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D4148 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FWD X-TUBE LUG ASSY | NTS |
| DATE | 10.10.12 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

Dart Aerospace Ltd

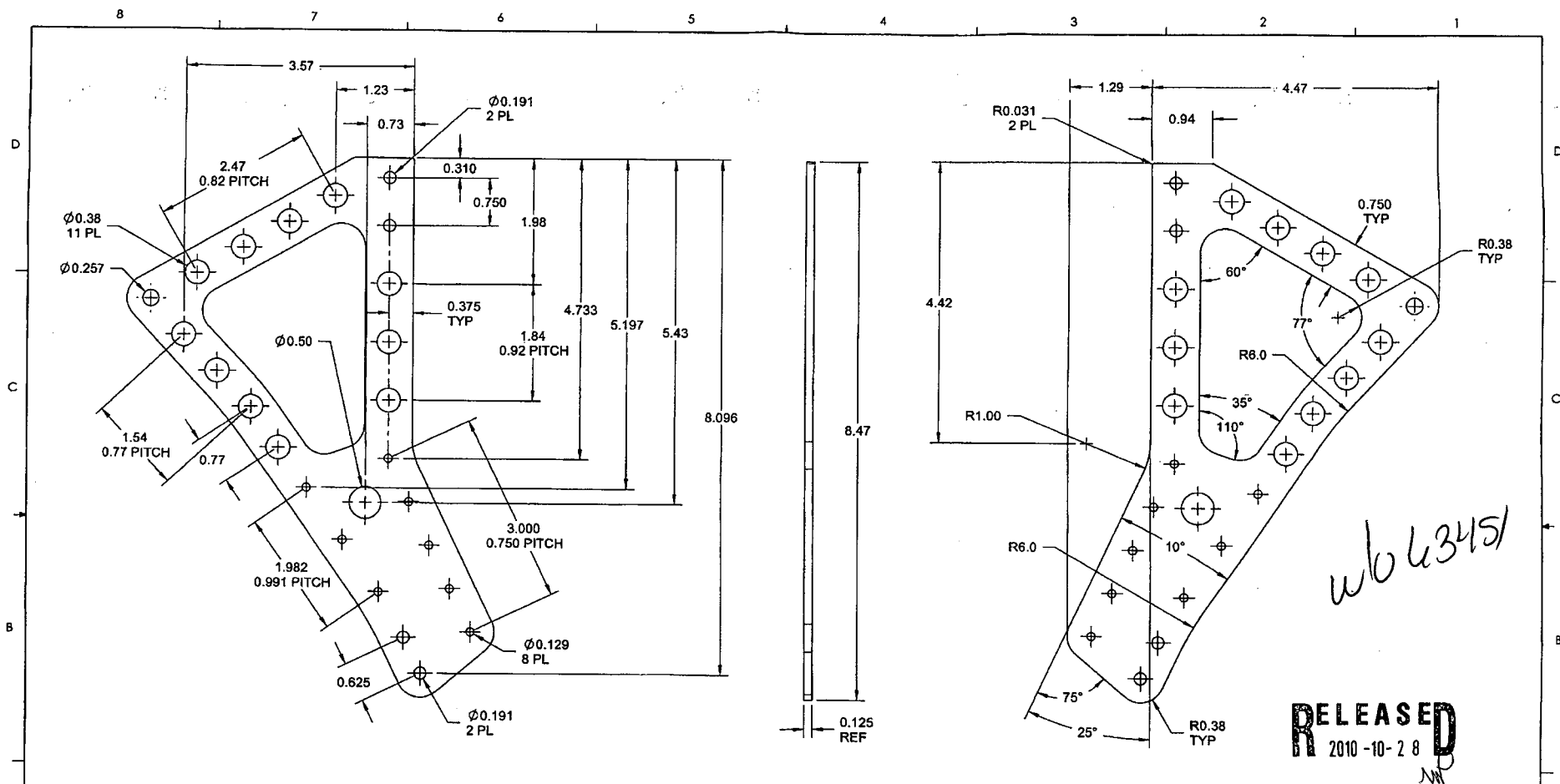
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| | | | | | | | | |

NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

| | | |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. C |
| MFG. APPR. | | D4148 SHEET 3 OF 5 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | FWD X-TUBE LUG ASSY NTS |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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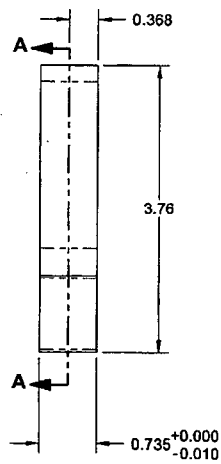
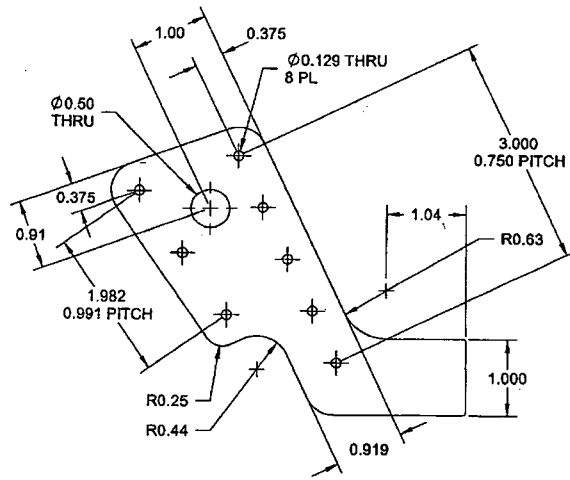
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

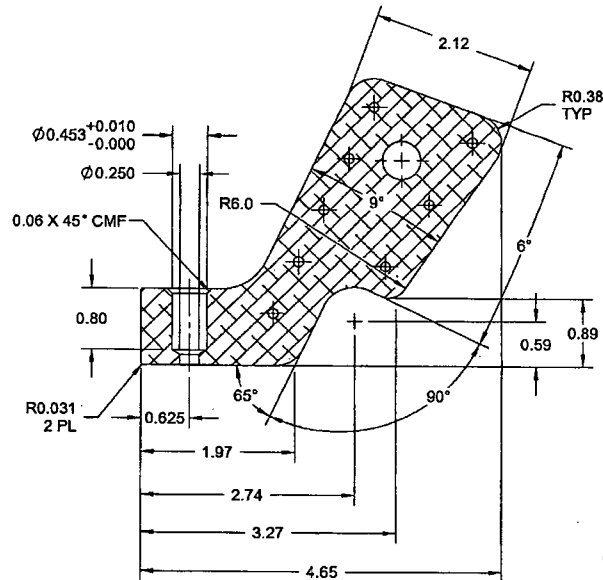
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C

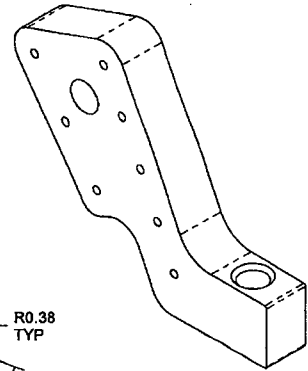
B



D4148-3 STUD RECEIVER LOWER



SECTION A-A



w/b 63451

RELEASED
2010-10-28

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276 REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.52 lbs

| | | | |
|------------|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4148 | REV. C |
| MFG. APPR. | | TITLE | SHEET 4 OF 6 |
| APPROVED | | FWD X-TUBE LUG ASSY | SCALE |
| DE APPR. | | | NTS |
| DATE | 10.10.12 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

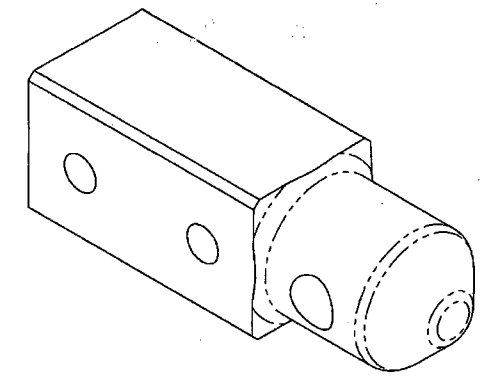
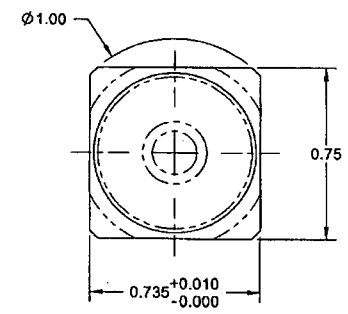
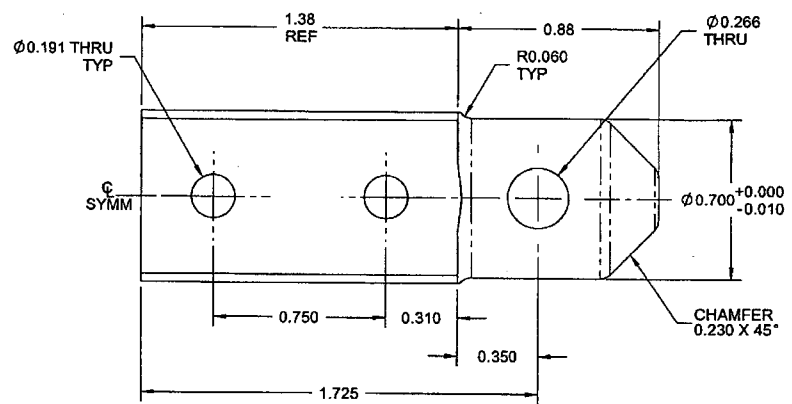
8 7 6 5 4 3 2 1

D

C

B

A



wlg 43451

D4148-5 EYEBOLT STUD

RELEASED
2010-10-28

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs

| | | | |
|------------|-----------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4148 | REV. C |
| MFG. APPR. | | TITLE | SHEET 5 OF 5 |
| APPROVED | | FWD X-TUBE LUG ASSY | SCALE |
| DE APPR. | | | NTS |
| DATE | 10.10.12 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries